| Work Order ID 84931 May-29-12 2:57:10 PM |                |                      |                                | *84931*             |            |                         |                 |        |              |               | Page       |       |                  |                |  |
|--|----------------|----------------------|--------------------------------|---------------------|------------|-------------------------|-----------------|--------|--------------|---------------|------------|-------|------------------|----------------|--|
| Item ID:<br>Revision ID:                 | D209-669-043   | 3                    |                                |                     |            | Accept                  | *N900           | 040    | 100          | )*            | Setup      | Start | *N               | S1*            |  |
| Item Name:                               | Replacement Sk | kidtube              |                                |                     | •          |                         | •               |        |              |               |            | Stop  | *NI              | <b>S</b> 2*    |  |
| Start Date:                              | 29/05/2012     | Start Q              | ty: 1.00                       | *                   | 1*         |                         | Cust Item 1     | ID:    | •            |               | (          |       | 1 14             | . 17           |  |
| Required Date:<br>Reference:             | 16/07/2012     | Req'd C              | <b>Qty:</b> 1.00               | *                   | 1*         |                         | Customer:       |        |              |               | ļ          | •     |                  |                |  |
| Approvals:                               | Process Plan   | : ML                 | <u></u>                        | Date: 12 /          | 05/79      | Tooling:                | D:              | ate:   | _            | I             | Run        | Start | *N               | R1*            |  |
|  | QC:            |                      |                                | Date:               | / '        | SPC (Y/N):              | D:              | ate:   |              |               |            | Stop  | *N               | R2*            |  |
| Sequence ID/<br>Work Center ID           |                | Operatio<br>Descript |                                |                     |            | Set Up/<br>Run Hours    | Tool ID         | Tool # | Plan<br>Code | Accept<br>Qty | Rej<br>Qty |       | Reject<br>Number | Insp.<br>Stamp |  |
| Draw Nbr                                 | Revis          | ion Nbr              |                                |                     |            |                         |                 |        |              |               |            |       |                  |                |  |
| D2906                                    | Rev B          | 3                    |                                |                     |            |                         |                 |        |              |               |            |       |                  |                |  |
| ¹00<br>*1∩∩*                             | 1              | DOCUME               | NT CONTRO                      | L                   |            | 0.00                    |                 |        |              |               | NA         | + *   | 9                | •              |  |
| DC                                       |                |                      | Memo                           |                     |            | 0.00                    | 043 Chg 002 par | 6.0.75 | AC.          |               | -/-        | (     | <del>]</del>     |                |  |
| Document Control                         |                |                      | Photocopy D                    | )209-669 bluefile   | & type lab | oels per PPP D205-669-0 | 043 Chg 002     | KNIUS  | U,           |               |            |       |                  |                |  |
|  |                |                      |                                |                     |            |                         |                 |        | h            |               |            |       |                  |                |  |
| 110                                      |                |                      |                                |                     |            |                         |                 |        |              |               |            |       | •                |                |  |
| *110*                                    |                | Skidtubes            |                                |                     |            | 0.00                    |                 |        |              |               |            |       |                  |                |  |
| Skidtubes<br>Skidtubes                   |                |                      | Memo - Inspect mat             | t'l D2500-1-190     | for damage | 0.00                    | 7               | CF     | 12.6         | 5-18          |            |       |                  |                |  |
| ·  |                |                      | -Drill pilot he cutting fluid) | oles using drill ji | g DT8149,  | DT8711-2 & DT8711-3     |                 |        |              |               |            |       |                  |                |  |
|  |                |                      | -Open holes                    | to 0.500" as per I  | Dwg D290   | 6 without cutting fluid | <b>\</b> .      |        |              |               |            |       |                  |                |  |
|  |                |                      |                                | blow out all chips  |            | -<br>-<br>-             | <u> </u>        | W.     | 12.0         | 26-1)         | >          |       | •                | •              |  |
|  |                |                      |                                | nd Alodine tube p   |            | 54.1                    |                 |        |              | 16            | 12-        | 61    | 8                | ·              |  |

| Dar | t Ae | ros | pace | Ltd |
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| W/O:    |                                  | ,                 |                      | .t. 16                       |                       |       |              |                               |                          |  |  |  |  |
|---------|----------------------------------|-------------------|----------------------|------------------------------|-----------------------|-------|--------------|-------------------------------|--------------------------|--|--|--|--|
| DATE    | STEP                             | PROC              | EDURE CH             | ANGE                         | 8                     | У     | Date Qty     | Approval Chief Eng / Prod Mgr | Approval<br>QC Inspector |  |  |  |  |
|         |                                  |                   |                      |                              |                       | •     |              |                               |                          |  |  |  |  |
|         |                                  |                   |                      |                              |                       |       |              |                               |                          |  |  |  |  |
|         |                                  |                   |                      |                              |                       |       |              |                               |                          |  |  |  |  |
|         |                                  |                   |                      |                              |                       |       |              |                               |                          |  |  |  |  |
|         |                                  |                   |                      |                              |                       |       |              |                               |                          |  |  |  |  |
| Part No | •                                | PAR #:            | _ Fault Ca           | tegory:                      | NCR:                  | Yes N | o DQA:       | Date: _                       |                          |  |  |  |  |
|         | R                                | esolution:        | _ Disposit           | ion:                         | QA: N/C Closed: Date: |       |              |                               |                          |  |  |  |  |
| NCR:    | WORK ORDER NON-CONFORMANCE (NCR) |                   |                      |                              |                       |       |              |                               |                          |  |  |  |  |
| DATE    | STEP                             | Description of NC | cription of NC Corre |                              | Section B             | ign & | Verification |                               | Approval                 |  |  |  |  |
|         |                                  | Section A         | Initial<br>Chief Eng | Action Description Chief Eng |                       | Date  | Section C    | Chief Eng                     | QC Inspector             |  |  |  |  |
| -       |                                  |                   |                      |                              |                       |       |              |                               |                          |  |  |  |  |
|         |                                  |                   |                      |                              |                       |       |              |                               |                          |  |  |  |  |
|         |                                  |                   |                      |                              |                       |       |              |                               |                          |  |  |  |  |
|         |                                  |                   |                      |                              |                       |       |              |                               |                          |  |  |  |  |
|         |                                  |                   |                      |                              |                       |       |              |                               |                          |  |  |  |  |
|         |                                  |                   |                      |                              |                       |       |              |                               |                          |  |  |  |  |
|         | •                                |                   |                      |                              |                       |       |              |                               |                          |  |  |  |  |
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| ,       |                                  |                   | -                    |                              |                       |       |              |                               |                          |  |  |  |  |
|         | 1                                | • -               |                      |                              |                       |       | 1            |                               | 1                        |  |  |  |  |

| <b>Work Ordo</b> <i>May-29-12 2:57</i>      |                           | 931  |   | *849   | 31*                      |            |              |               |             | ٠             |                  | Page 2         |
|---|---------------------------|--|---|--|--------------------------|------------|--------------|---------------|-------------|---------------|------------------|----------------|
| Item ID:<br>Revision ID:<br>Item Name:      | D209-669-04 Replacement S |  |   | Accept   | *N900                    | <b>040</b> | 100          | )*            | Setup       | Start<br>Stop | 1 71             | S1*            |
| Start Date:<br>Required Date:<br>Reference: | 29/05/2012<br>16/07/2012  | Start Qty: 1.00<br>Req'd Qty: 1.00             | *1*<br>*1*  |  | Cust Item I<br>Customer: | D:         |              |               |             |               | TN.              | S2*            |
| Approvals:                                  |                           | n:   | Date:   |  |                          | ate:       |              | i             | Run         | Start<br>Stop | *N <br>*N        | R1*<br>R2*     |
| Sequence ID/<br>Work Center II<br>120       |                           | Operation Description QC3- Inspect Part Finish |   | Set Up/<br>Run Hours   | Tool ID                  | Tool #     | Plan<br>Code | Accept<br>Qty | Rejo<br>Qty |               | Reject<br>Number | Insp.<br>Stamp |
| *120*<br>QC<br>Quality Control              |                           | Мето   |   | 0.00   |                          |            |              |               |             |               | SAO              | 12-06-1        |
| <sup>130</sup><br>*130*                     |                           | Skidtubes                                      |   | 0.00   |                          |            |              | <i>(</i> 1    | -A          |               | /o /             | 10             |
| Skidtubes<br>Skidtubes                      |                           | Pick:<br>Qty Part Nui<br>A/R Sikafl            | mber Description Bar<br>lex-291 M/D<br>re date: /3-4-12<br>5:45 Date: | 0.00  Allow 12 Hrs. cure time before of the control | cutting                  |            |              |               | <b>V</b>    |               | 12.6             | / <u>D</u>     |

pick: Qty 1

P/N D2926-3 description Web

| W/O:        |      |                                | V                 | IANGES                          |                       |          |       |                                   | •                             |                          |  |  |  |
|-------------|------|--------------------------------|-------------------|---------------------------------|-----------------------|----------|-------|-----------------------------------|-------------------------------|--------------------------|--|--|--|
| DATE        | STEP | PRO                            | CEDURE CH         | IANGE                           |                       | Ву       | Date  | Qty                               | Approval Chief Eng / Prod Mgr | Approval<br>QC inspector |  |  |  |
|             |      | *                              |                   |                                 |                       |          | •     |                                   |                               |                          |  |  |  |
|             |      |                                | Ĉ.                |                                 | er .                  | •        |       |                                   |                               |                          |  |  |  |
|             |      |                                |                   |                                 |                       |          |       |                                   |                               |                          |  |  |  |
| Part No     | •    | PAR #:                         | _ Fault Ca        | tegory:                         | NC                    | R: Yes   | No DQ | <b>A:</b>                         | Date:                         | par tark                 |  |  |  |
| Resolution: |      | esolution:                     | Disposit          | ion:                            | QA: N/C Closed: Date: |          |       |                                   |                               |                          |  |  |  |
| NCR:        |      | W                              | ORK OR            | DER NON-CONFO                   | ORMANCE               | CE (NCR) |       |                                   |                               |                          |  |  |  |
| DATE        | STEP | Description of NC<br>Section A | Initial Chief Eng | Corrective Action Action Descri | Section B ption       | Sign &   |       | ication Approval tion C Chief Eng |                               | Approval<br>QC Inspector |  |  |  |
|             |      |                                |                   |                                 |                       |          |       |                                   | ·                             |                          |  |  |  |
|             |      | *                              |                   | ·                               |                       |          |       |                                   |                               |                          |  |  |  |
|             |      |                                |                   |                                 |                       |          |       |                                   |                               |                          |  |  |  |
|             |      |                                |                   |                                 |                       |          |       |                                   |                               |                          |  |  |  |
|             |      |                                |                   |                                 |                       |          |       |                                   |                               |                          |  |  |  |
|             |      |                                |                   |                                 |                       |          |       |                                   |                               |                          |  |  |  |

| Work Order ID 84931  May-29-12 2:57:10 PM |             |                          | *84931*                  |  |                            |        |              |               |               | Page 3           |                |  |
|---|-------------|--------------------------|--------------------------|--|----------------------------|--------|--------------|---------------|---------------|------------------|----------------|--|
| Item ID:<br>Revision ID:                  | D209-669-0  | 43                       |                          | Accept   | *N900                      | 040    | 100          | )* ·          | Setup Sta     | rt *N            | S1*            |  |
| Item Name:                                | Replacement | Skidtube                 |                          |  |                            |        |              |               | Sto           | p *\1            | C2*            |  |
| Start Date:                               | 29/05/2012  | Start Qty: 1.00          | ` *1*                    |  | Cust Item I                | D•     |              |               |               | 14               | .7/            |  |
| Required Date:                            | 16/07/2012  | <b>Req'd Qty:</b> 1.00   | *1*                      |  | Customer:                  | ν.     |              |               |               |                  |                |  |
| Reference:                                |             |                          | ,                        |  |                            |        |              |               |               |                  |                |  |
| Approvals:                                | Process Pla | n:                       | Date:                    | Tooling:   | Da                         | ıte:   | _            | I             | Run Sta       | "   \            | R1*            |  |
|   | QC:         | ·                        | Date:                    | SPC (Y/N):   | Da                         | ite:   |              |               | Sto           | *N               | R2*            |  |
| Sequence ID/<br>Work Center II            | )           | Operation<br>Description |                          | Set Up/<br>Run Hours   | Tool ID                    | Tool # | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp |  |
| *140*                                     |             | BENDING MACHINE -        | - CROSSTUBES             | 0.00   |                            |        |              |               |               |                  |                |  |
| CNC Bend I                                |             | Memo                     |                          | 0.00   |                            |        |              |               |               |                  |                |  |
| CNC Delta 100 Ben                         | der         | 1-Bend as po             | er program COB43FWD      | & COBRAFT on CNC Ber   | nder and Folio FT          |        |              | n,            | 2/21          | /, -             |                |  |
|   | ,           | 2-Cut tubes              | as per Dwg. D2906        |  |                            | /      |              | G.            | 2/06/         | 19               | ,              |  |
| 150                                       |             |                          |                          | 0.00   | 6                          |        |              | -,            |               |                  |                |  |
| *150*                                     |             | Skidtubes                |                          |  |                            |        |              |               |               |                  |                |  |
| Skidtubes                                 |             | Memo                     |                          | 0.00   | 0.5 10                     |        |              |               |               |                  | -              |  |
| Skidtubes                                 |             | -Deburr ends             | s and remove markes from | m bending  | > CF 12                    | 2-6-19 |              | 1             |               |                  |                |  |
|   |             | and dwg. Ho              | old x-bolt with DT9701 U | QSI002 and trim/ grind fluse tube expander 1/2 x17G o achieve dwg dimention. | ish per QSI002<br>to start | CF     | 12.7         | ·5/           |               |                  |                |  |
| 160                                       |             | QC5- Inspect part comple | eteness to step on W/O   | 0.00   |                            |        |              |               |               |                  |                |  |
| *160*                                     |             |                          |                          |  |                            |        |              | <i>†</i>      | ð             | A.               | while          |  |
| QC  |             | Memo                     |                          | 0.00   |                            |        |              |               |               | <u> </u>         | 70705          |  |

. Quality Control

| Dail Ac | Ospace | FLICE                          |                      |                |                |                           |   |                       |                               | ,                        |
|---------|--------|--------------------------------|----------------------|----------------|----------------|---------------------------|---|-----------------------|-------------------------------|--------------------------|
| W/O:    |        |                                | W                    | ORK ORDER CHAN | IGES           |                           | ,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,, |                       |                               | 3                        |
| DATE    | STEP   | PROC                           | EDURE CHA            | NGE            | 1              | Зу                        | Date                                    | Qty                   | Approval Chief Eng / Prod Mgr | Approval<br>QC Inspector |
|         |        |                                |                      | *1             |                |                           |   |                       |                               |                          |
|         |        |                                |                      | ····           |                |                           |   |                       |                               |                          |
|         |        |                                |                      | ,              |                |                           |   |                       |                               |                          |
|         |        | PAR #:                         |                      |                |                |                           |   |                       |                               |                          |
|         |        | esolution:                     | _ Dispositio         | n:             | QA: N          | VC Clos                   | sed:                                    |                       | Date: _                       |                          |
| NCR:    |        | W                              | ORK ORD              | ER NON-CONFORM | MANCE (        | NCR)                      |   |                       |                               |                          |
|         | STEP   | Description of NC<br>Section A | Initial<br>Chief Eng |                | Sign &<br>Date | Verification<br>Section C |   | Approval<br>Chief Eng | Approval<br>QC Inspector      |                          |
|         |        |                                |                      | Chief Eng      |                |                           |   |                       |                               | ,                        |
|         |        |                                |                      |                |                |                           |   |                       |                               |                          |
| (* \ \  |        |                                |                      |                |                |                           |   |                       |                               |                          |
|         |        |                                |                      |                |                |                           |   |                       | ·                             |                          |
|         |        | ~                              |                      |                |                |                           |   |                       |                               |                          |
|         |        |                                |                      |                |                |                           |   |                       |                               |                          |

Work Order ID 84931 Page 4 May-29-12 2:57:10 PM Item ID: D209-669-043 Accept \*N900040100\* Setup Start **Revision ID: Item Name:** Replacement Skidtube **Start Date:** 29/05/2012 Start Qty: 1.00 **Cust Item ID: Required Date:** 16/07/2012 Req'd Qty: 1.00 **Customer:** Reference: Run Start Approvals: Process Plan: Date:\_\_\_\_ Tooling: Date: Stop Date:\_\_\_\_\_ SPC (Y/N): Date: Sequence ID/ Operation Set Up/ Tool ID Tool # Plan Reject Accept Reject Insp. **Work Center ID Description Run Hours** Code Qty Qty Stamp Number 170 0.00 Large Fab \*170\* Skidtubes 0.00 Skidtubes -Drill holes for wearplates using DT8217 Open holes to 19/64", adjust stopper not to hit web.Deburr -Drill pilot holes for aft & fwd cap using DT8215 open holes to #6" Deburr -Drill pilot holes for Tow ring using DT8091-3 , open to .640" and Deburr

5010015

0.00

0.00

QC5- Inspect part completeness to step on W/O

Memo

190

QC

\*190\*

Quality Control

| Dart Aerospace | Ltd |
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| W/O:    |      | WORK ORDER CHANGES |                                  |                              |           |                                       |             |                               |                          |  |  |
|---------|------|--------------------|----------------------------------|------------------------------|-----------|---------------------------------------|-------------|-------------------------------|--------------------------|--|--|
| DATE    | STEP | PRO                | CEDURE CH                        | ANGE                         | Ву        | Date                                  | Qty         | Approval Chief Eng / Prod Mgr | Approval<br>QC Inspector |  |  |
|         |      |                    |                                  |                              |           |                                       |             |                               |                          |  |  |
|         |      |                    |                                  |                              |           |                                       |             |                               |                          |  |  |
|         |      |                    |                                  |                              |           | · · · · · · · · · · · · · · · · · · · |             |                               |                          |  |  |
|         |      |                    |                                  |                              |           |                                       |             |                               |                          |  |  |
|         |      |                    |                                  |                              |           |                                       |             |                               |                          |  |  |
| Part No | :    | PAR #:             | Fault Cat                        | egory:                       | NCR: Yes  | No <b>DQ</b>                          | A:          | Date: _                       |                          |  |  |
|         | R    | esolution:         | _ Dispositi                      | on:                          | QA: N/C C | osed:                                 | <del></del> | Date: _                       |                          |  |  |
| NCR:    |      | V.                 | WORK ORDER NON-CONFORMANCE (NCR) |                              |           |                                       |             |                               |                          |  |  |
| DATE    | CTED | Description of NC  |                                  | Corrective Action Section    |           | Verifi                                | Approval    | Approval                      |                          |  |  |
| DATE    | STEP | Section A          | Initial<br>Chief Eng             | Action Description Chief Eng | Sign a    | Sect                                  | Chief Eng   | QC Inspector                  |                          |  |  |
|         |      |                    |                                  |                              |           |                                       |             |                               |                          |  |  |
|         |      |                    |                                  |                              |           |                                       |             |                               |                          |  |  |
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|         |      | ·                  |                                  |                              |           |                                       |             |                               |                          |  |  |
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|         |      |                    |                                  |                              |           |                                       |             |                               |                          |  |  |
|         |      |                    |                                  |                              |           |                                       |             |                               |                          |  |  |
|         |      |                    |                                  |                              | I         | L .                                   |             | 1                             | 1                        |  |  |

| Work Orde<br>May-29-12 2:57                                     |   | 1931   |                 | *849                         | 331*      |       |              | <del></del>   |            |               |                  | Page 5         |
|---|---|--|-----------------|------------------------------|-----------|-------|--------------|---------------|------------|---------------|------------------|----------------|
| Revision ID:<br>Item Name:<br>Start Date:                       | D209-669-0<br>Replacement<br>29/05/2012 | Skidtube Start Qty: 1.00                                     | *1*             | Accept                       | *N900     |       | 100          | )*°           | Setup      | Start<br>Stop | *N:              | S1*<br>S2*     |
| Required Date:<br>Reference:                                    | 16/07/2012                              | Req'd Qty: 1.00  | *1*             |                              | Customer: |       |              |               |            |               |                  |                |
| Approvals:  | Process Pla                             | an:  | Date:           | Tooling: SPC (Y/N):          |           | ite:  |              |               | Run        | Start<br>Stop | *NI<br>*NI       | ₹1*<br>₹2*     |
| Sequence ID/ Work Center II 200 *200* HandFinish Hand Finishing |   | Operation Description Pressure Wash per QS100 Memo           | 05 4.3          | Set Up/<br>Run Hours<br>0.00 | Tool ID   | Tool# | Plan<br>Code | Accept<br>Qty | Rej<br>Qty |               | Reject<br>Number | Insp.<br>Stamp |
| 210 *210* Powdercoat Powder Coating                             | 341                                     | White Gloss(Ref:4.3.5.1)  Memo START TIM OVEN TEM FINISH TIM | 3703<br>E: 371. | 0.00<br>0.00<br>U            |           |       |              | <u>/</u> /    | J.         |               |                  | ML<br>12/07/   |
| <sup>220</sup><br>* <b>ク</b> ク <b>∩</b> *<br><sup>QC</sup>      |   | QC3- Inspect Part Finish                                     | <b>5</b>        | 0.00                         |           |       |              |               | R          | (             |                  | 12/07/06       |

Quality Control

| W/O:    |      |                                       | WORK ORDER CHANGES                 |                    |   |        |         |     |                               |                          |  |  |  |  |
|---------|------|---------------------------------------|------------------------------------|--------------------|---|--------|---------|-----|-------------------------------|--------------------------|--|--|--|--|
| DATE    | STEP | PRO                                   | CEDURE CH                          | IANGE              |   | Ву     | Date    | Qty | Approval Chief Eng / Prod Mgr | Approval<br>QC Inspector |  |  |  |  |
|         |      |                                       | . '                                |                    |   |        |         |     |                               | ·                        |  |  |  |  |
|         |      |                                       |                                    |                    |   |        |         |     |                               |                          |  |  |  |  |
|         |      |                                       |                                    |                    |   |        |         |     |                               | ٠                        |  |  |  |  |
|         |      |                                       |                                    |                    |   |        |         |     |                               |                          |  |  |  |  |
| Part No | •    | PAR #:                                | Fault Ca                           | tegory:            | NCF                                     | Yes I  | No DQA: |     | _ Date: _                     |                          |  |  |  |  |
|         | R    | · · · · · · · · · · · · · · · · · · · | Disposition: QA: N/C Closed: Date: |                    |   |        |         |     |                               |                          |  |  |  |  |
| NCR:    |      | <b>V</b>                              | VORK OR                            | DER NON-CONFORM    | MANCE                                   | (NCR   | )       |     |                               |                          |  |  |  |  |
|         | STEP | Description of NC<br>Section A        | Initial                            | Action Description | ection B                                | Sign & |         |     | Approval<br>Chief Eng         | Approval<br>QC Inspector |  |  |  |  |
|         |      |                                       | Chief Eng                          | Chief Eng          |   | Date   |         |     |                               |                          |  |  |  |  |
|         |      |                                       |                                    |                    |   |        |         |     |                               |                          |  |  |  |  |
|         |      |                                       |                                    |                    |   |        |         |     |                               |                          |  |  |  |  |
|         |      |                                       |                                    |                    | *************************************** | -,     |         |     |                               |                          |  |  |  |  |
|         |      |                                       |                                    |                    |   |        |         |     |                               |                          |  |  |  |  |
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|         |      |                                       |                                    |                    | Ż                                       |        |         |     |                               |                          |  |  |  |  |
|         |      |                                       |                                    |                    |   |        |         |     |                               |                          |  |  |  |  |
|         |      |                                       |                                    |                    |   |        |         |     |                               |                          |  |  |  |  |

| <b>Work Orde</b> <i>May-29-12 2:57</i>                          |                        | 84931                           |  |  | *849                          | 931*                   |        |              |              |              |               |                  | Page 6         |
|---|------------------------|---------------------------------|--|--|-------------------------------|------------------------|--------|--------------|--------------|--------------|---------------|------------------|----------------|
| Item ID:<br>Revision ID:<br>Item Name:                          | D209-669               | 9-043<br>ent Skidtube           |  |  | Accept                        | *N900                  | )040   | 100          | )*           | Setup        | Start<br>Stop | *N<br>*N         | S1*<br>S2*     |
| Start Date:<br>Required Date:<br>Reference:                     | 29/05/201<br>16/07/201 | ~ .                             |  | *1*<br>*1*   |                               | Cust Item<br>Customer: |        |              |              |              |               | 1.4              | . 12           |
| Approvals:  | Process QC:            | Plan:                           |  | ate:   | Tooling: SPC (Y/N):           |                        | Pate:  |              |              | Run          | Start<br>Stop | *N<br>*N         | R1*<br>R2*     |
| Sequence ID/ Work Center ID 230 *730* HandFinish Hand Finishing |                        | 1-<br>in<br>A<br>Si<br>2-<br>pe | Jemo -Install inserts & sert holes before //R Sikaflex-2 ikaflex expire da -Coat D2594-3 (er Dwg D2906 | e installing wearpla<br>291 (21409<br>tte: 13/07                           | eum Jelly and install on D2   |                        | Tool # | Plan<br>Code | Accep<br>Qty | t Rej<br>Qty |               | Reject<br>Number | Insp.<br>Stamp |
|   |                        | 4-<br>wi<br>A/<br>Sil           | Install D2855 F<br>ith Sikaflex. Cle<br>/R Sikaflex<br>kaflex expire da                                | wd & Aft Cap as pean excess adhesive 291 121409 te: 13/01 er Dwg D2906 and | er Dwg D2906 and seal Fv<br>: | wd & Aft Cap           |        |              |              |              |               |                  |                |

| WORK ORDER CHANGES  DATE   STEP   PROCEDURE CHANGE   By   Date   Qty   Approval Chief Eng / Prod Mgr   QC Inspector    Part No: PAR #: Fault Category: NCR: Yes No DQA: Date:    Resolution: Disposition: QA: N/C Closed: Date:    NCR: WORK ORDER NON-CONFORMANCE (NCR)  DATE   STEP   Description of NC Section A   Chief Eng   Chief En |      |            |           |                    |        |  |       |             |             |                          |
|--|------|------------|-----------|--------------------|--------|--|-------|-------------|-------------|--------------------------|
| W/O:   |      |            |           |                    |        |  |       |             |             |                          |
| DATE   | STÉP | PRO        | CEDURE CH | IANGE              |        | Ву   | Date  | Qty         | Chief Eng / | Approval<br>QC Inspector |
|  |      |            |           |                    |        |  |       |             |             |                          |
|  |      |            |           |                    |        |  |       |             | 1           |                          |
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| Part No  | :    | PAR #:     | Fault Ca  | tegory:            | NCR    | : Yes N  | lo DQ | A:          | Date:       |                          |
|  | R    | esolution: | Disposit  | ion:               | QA:    | N/C Clo  | sed:  |             | Date: _     |                          |
| NCR:   |      | V          | VORK OR   | DER NON-CONFORM    | ANCE   | (NCR)  | )     |             |             |                          |
| DATE   | STEP |            |           | Action Description | tion B |  |       |             |             |                          |
|  |      |            | Chief Eng | Chief Eng          |        | Date   |       |             |             |                          |
| ·-   |      |            |           |                    |        |  |       |             |             |                          |
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| 1  |      | · '        | 1         |                    |        |  | l     |             |             |                          |

| Work Orde  May-29-12 2:57        |             | 931                                |  | *84                     | 931*                  |              |              |               |              |               |                  | Page 7         |
|----------------------------------|-------------|------------------------------------|--|-------------------------|-----------------------|--------------|--------------|---------------|--------------|---------------|------------------|----------------|
| Item ID: Revision ID: Item Name: | D209-669-0  |                                    |  | Accept                  | *N900                 | <b>1</b> 040 | 100          | )*            | Setup        | Start<br>Stop | *N:              | S1*            |
|                                  | 29/05/2012  | Start Qty: 1.00<br>Req'd Qty: 1.00 | *1*<br>*1*                                 |                         | Cust Item<br>Customer |              |              |               |              | эгор          | *N:              | S2*            |
| Approvals:                       | Process Pla | n:                                 | Date:                                      | Tooling:                | ]                     | Date:        |              |               | Run          | Start         | *N               | R1*            |
|                                  | QC:         |                                    | Date:                                      | _ SPC (Y/N):            | I                     | Date:        |              |               |              | Stop          | *NI              | R2*            |
| Sequence ID/<br>Work Center II   | )           | Operation Description              |  | Set Up/<br>Run Hours    | Tool ID               | Tool #       | Plan<br>Code | Accept<br>Qty | t Rej<br>Qty |               | Reject<br>Number | Insp.<br>Stamp |
| 240                              | •           | QC5- Inspect part compl            | eteness to step on W/O                     | 0.00                    |                       |              | Couc         | Qty           | Qiy          | 1             | vamber           | Stamp          |
| * <b>240</b> *                   |             | Memo                               |  | 0.00                    | 7/03/00               |              |              |               |              |               |                  |                |
| Quality Control                  |             | Inspect Aft (<br>Foreign obje      | Cap, Fwd Step and Wing<br>ects per QSI 024 | Walk of work to Current | Step Inspect for      |              |              |               |              |               |                  |                |
| 250                              |             |                                    |  | 0.00                    |                       |              |              |               |              |               |                  |                |
| *250*                            |             | Packaging                          |  |                         |                       |              |              |               |              |               | _                |                |
| Packaging<br>Packaging           |             | Memo                               | pack for shipping as per l                 | 0.00                    |                       |              |              |               |              |               | //               |                |
|                                  |             | Location:<br>PPP Rev:              | F 7  |                         |                       |              |              |               | C            | 10            | 12/1             | 2)5            |
| *260<br>*260*                    |             | QC21- Final Inspection -           | Work Order Release                         | 0.00                    |                       |              |              |               |              | 10            | 1/1/1            | $\mathcal{A}$  |
| QC                               |             | Memo                               |  | 0.00                    |                       |              |              |               |              | /W /          | /////            | 8_ <i>TX</i> ) |
| Quality Control                  |             |                                    |  |                         |                       |              |              |               |              |               | $\wedge$         | MAR            |

Mr (2-02-17)

| Duit Mo | oopaoc | Liu               |                      |                              |            |         |        |                                     |                                       |
|---------|--------|-------------------|----------------------|------------------------------|------------|---------|--------|-------------------------------------|---------------------------------------|
| W/O:    |        |                   | V                    | ORK ORDER CHANG              | ES         |         |        |                                     |                                       |
| DATE    | STEP   | PRO               | CEDURE CH            | IANGE                        | Ву         | Date    | Qty    | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector              |
|         |        |                   |                      |                              |            |         |        |                                     |                                       |
|         |        |                   |                      |                              |            |         |        |                                     |                                       |
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|         |        |                   |                      |                              |            |         |        |                                     |                                       |
| Part No |        | PAR #:            |                      |                              |            |         |        |                                     |                                       |
|         | R      | esolution:        | Disposit             | ion:                         | _ QA: N/C  | Closed: |        | Date: _                             | · · · · · · · · · · · · · · · · · · · |
| NCR:    |        | V                 | VORK OR              | DER NON-CONFORM              | ANCE (NO   | R)      |        |                                     |                                       |
| DATE    | STEP   | Description of NC |                      |                              | ion B      |         | cation | Approval                            | Approval                              |
| DAIL    | J      | Section A         | Initial<br>Chief Eng | Action Description Chief Eng | Sigr<br>Da | te Sec  | tion C | Chief Eng                           | QC Inspector                          |
|         |        | ·                 |                      |                              |            |         |        | -<br>-                              |                                       |
|         |        |                   |                      |                              |            |         |        |                                     |                                       |
|         |        |                   |                      |                              |            |         |        |                                     |                                       |
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|         |        |                   |                      |                              |            |         |        |                                     |                                       |
|         |        |                   | •                    |                              |            |         |        |                                     |                                       |
|         |        |                   |                      |                              |            |         |        |                                     |                                       |
|         |        |                   |                      |                              |            |         | ,      |                                     |                                       |
|         |        | ***               |                      |                              |            |         |        |                                     |                                       |
|         |        |                   |                      |                              |            |         |        |                                     |                                       |

## **Picklist Print**

. May-29-12 -2:57:14 PM

Work Order ID: 84931

\*84931\*

**Parent Item:** D209-669-043

\*D209-669-043\*

Parent Item Name:

Replacement Skidtube

**Start Date:** 29/05/2012

**Required Date:** 16/07/2012

Page 1

Start Qty: 1.00

Required Qty: 1.00

Comments:

new IPP 08.02.13 LL, verified by: DD

IPP Rev:B remove DT # in seq140 DD 10.03.10 Verified by:EC

| Component Item ID/<br>Item Name                | Replacement<br>Item ID | Mfg/<br>Purch | Bin<br>Item | Primary<br>Location           | Last<br>Location          | Route<br>Seq ID | Unit of<br>Measure     |          | Qty per Kit | Total<br>Qty | Qty<br>Issued | Date<br>Issued | Status     |
|--|------------------------|---------------|-------------|-------------------------------|---------------------------|-----------------|------------------------|----------|-------------|--------------|---------------|----------------|------------|
| D4202-1 *D4202-1* Spacer                       |                        | Manufactured  | No          | B832                          |                           | (-              | Each                   | 81.0000  | **          | 19           | OF 12         | .7.5           |            |
| •  |                        |               |             | B847<br><u>Location</u><br>LG | !                         | <u>Loc</u>      | 0117)<br>0117<br>- 5   | Loc Code | _           |              | -             |                |            |
|  |                        |               |             | LG002                         | 77727<br>78806<br>79810   |                 | 5<br>76<br>6           |          |             |              | <u>-</u><br>- |                |            |
| D2500-1-190  *D2500-1- Ext'n -`I' Beam Tube 4" | 190*                   | Manufactured  | No          |                               | 79810                     | 110             | 70<br>Each             | 91.0000  | 1<br>**     | 1            |               | FL             | B-18       |
|  |                        |               |             | <u>Location</u><br>HALL       | <b>74</b> 777             | Loc             | <u>Otv</u><br>91<br>14 | Loc Code | . <u> </u>  |              |               |                |            |
| <sup>D2926-3</sup><br>*D2926-3*                |                        | Manufactured  | No          | B84                           | 1949                      | 110             | 77<br>Each             | 0.0000   | 1<br>**     |              | Œ             | 12.6-1         | 18         |
| Web<br>D2855<br>*D2855*<br>Cap                 |                        | Manufactured  | No          | <i>V</i> 09                   | 771                       | 230             | Each                   | 21.0000  | 2<br>**     | 2            |               | 12/1           | ±<br>24/09 |
|  | ·                      | X             |             |                               | 84952/<br>65519<br>73347/ | Loc             | Oty<br>21<br>2<br>16   | Loc Code |             | l            | -             | ·              | v          |

| Duit Ac | ospaoc | Liu                            |           |                   |         |                                       |                    |     |                               |                          |
|---------|--------|--------------------------------|-----------|-------------------|---------|---------------------------------------|--------------------|-----|-------------------------------|--------------------------|
| W/O:    | -      |                                | V         | VORK ORDER CHAN   | IGES    |                                       |                    |     |                               | <b>U</b>                 |
| DATE    | STEP   | PRO                            | CEDURE CH | IANGE             | E       | Ву                                    | Date               | Qty | Approval Chief Eng / Prod Mgr | Approval<br>QC Inspector |
|         |        |                                |           |                   |         |                                       |                    |     |                               |                          |
|         |        |                                |           |                   |         |                                       |                    |     |                               |                          |
|         |        |                                |           |                   |         |                                       |                    |     |                               |                          |
| Part No | :      | PAR #:                         | Fault Ca  | tegory:           | NCR:    | Yes N                                 | o DQA              | \:  | _ Date: _                     |                          |
|         | R      | esolution:                     | Disposit  | tion:             | QA: N   | /C Clos                               | sed:               |     | Date: _                       |                          |
| NCR:    |        | V                              | ORK OR    | DER NON-CONFOR    | MANCE ( | NCR)                                  |                    |     |                               |                          |
| DATE    | STEP   | Description of NC<br>Section A | Initial   | Action Descriptio |         | Sign &                                | Verific<br>Section |     | Approval<br>Chief Eng         | Approval<br>QC Inspector |
|         |        |                                | Chief Eng | Chief Eng         |         | Date                                  |                    |     |                               |                          |
| -       |        |                                |           |                   |         |                                       |                    |     |                               |                          |
|         |        |                                |           |                   |         |                                       |                    |     |                               | ·                        |
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|         |        |                                |           |                   |         |                                       |                    |     |                               |                          |

May-29-12 2:57:14 PM

Work Order ID: 84931

Parent Item:

D209-669-043

Parent Item Name: Replacement Skidtube

\*84931\*

Location

ST350

No

\*D209-669-043\*

Start Date: 29/05/2012

**Required Date:** 16/07/2012

Start Qty: 1.00

\*\*

Required Qty: 1.00

AN3-5A

Bolt



AN960JD10L

\*AN960JD10L\*

Washer

ALS7-1032-130

Purchased

Purchased

No

No

12/011

115371

117423

119355

120187

121185

118626

230

230

230

Each

Loc Qty

1090

46

124

31

200

500

189

Each

Each

2,136.000

1,090.000

Loc Code

0.0000

Loc Code

\*\*

\*\*

44

12/07/06

\*ALS7-1032-130\* Insert



| Locatio |         | Loc Qty |
|---------|---------|---------|
| ST280   | 1212692 | 51      |
|         | 117717  | 27      |
|         | 118966  | 22      |
|         | 119775  | 2       |
| ST282   |         | 2085    |
|         | 119530  | 73      |
|         | 120181  | 12      |
|         | 121444  | 2000    |

| W/O:         |          |                   | W          | ORK ORDER CHA                | ANGES                                 |         |                | <del> </del> |                               | ١                        |
|--------------|----------|-------------------|------------|------------------------------|---------------------------------------|---------|----------------|--------------|-------------------------------|--------------------------|
| DATE         | STEP     | PRO               | CEDURE CHA | NGE                          |                                       | Ву      | Date           | Qty          | Approval Chief Eng / Prod Mgr | Approval<br>QC Inspector |
|              |          |                   |            |                              |                                       |         | •              |              |                               |                          |
|              |          |                   |            |                              |                                       |         |                |              |                               |                          |
| <del> </del> |          |                   |            |                              | · · · · · · · · · · · · · · · · · · · |         |                |              |                               |                          |
|              |          |                   |            |                              |                                       |         |                |              |                               |                          |
| Part No      | :        | PAR #:            | Fault Cate | gory:                        | NCR                                   | : Yes N | lo <b>DQ</b> / | A:           | Date:                         |                          |
|              |          | esolution:        |            |                              |                                       |         |                |              |                               |                          |
| NCR:         |          | V                 | VORK ORD   | ER NON-CONFO                 | RMANCE                                | (NCR)   |                |              |                               |                          |
| DATE         | STEP     | Description of NC | Initial    | Corrective Action            | Section B                             | Sign &  | Verific        |              | Approval                      | Approval                 |
|              |          | Section A         | Chief Eng  | Action Descript<br>Chief Eng | uon                                   | Date    | Secti          | on C         | Chief Eng                     | QC Inspector             |
| -            |          |                   |            |                              |                                       |         |                |              |                               |                          |
|              |          |                   |            |                              |                                       |         |                |              |                               |                          |
|              |          |                   |            |                              |                                       |         |                | ·            |                               |                          |
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|              | <u> </u> | ·                 |            |                              |                                       |         |                |              |                               |                          |
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| 1 -          | 1        | 1                 | 1          |                              |                                       |         | 1              |              | I                             | 1                        |

230

122063

Manufactured

No

| Location | Loc Qty | Loc Code |             |
|----------|---------|----------|-------------|
| FP001    | . 2418  |          |             |
| 65518    | 41      |          |             |
| 79496    | 984     |          |             |
| 79573    | 50      |          | <del></del> |
| 79755    | 1343    |          |             |

Each

\*\*

\*\*

14

14

14

2,418.000

\*AN960C101 \*

\*D2594-3\*

O-Ring, 205 Skidtube

washer D2594-3

| W/O:    |      |                                | W                    | ORK ORDER CHANG  | ES                   |         |            |                               | • h                      |
|---------|------|--------------------------------|----------------------|--|----------------------|---------|------------|-------------------------------|--------------------------|
| DATE    | STEP | PRO                            | CEDURE CH            | IANGE  | Ву                   | Date    | Qty        | Approval Chief Eng / Prod Mgr | Approval<br>QC Inspector |
|         |      |                                |                      |  |                      |         |            |                               |                          |
|         |      |                                |                      |  |                      |         |            |                               |                          |
| ·       |      |                                |                      |  |                      |         |            |                               |                          |
|         |      |                                |                      |  |                      |         |            |                               |                          |
|         |      |                                |                      |  |                      |         |            |                               |                          |
| Part No | ·    | PAR #:                         | Fault Ca             | tegory:  | NCR: Yes             | No DQ   | <b>A</b> : | Date: _                       |                          |
|         | R    | esolution:                     | Disposit             | ion:   | _ QA: N/C (          | closed: |            | Date: _                       |                          |
| NCR:    |      | V                              | VORK OR              | DER NON-CONFORMA                                       | NCE (NC              | R)      |            |                               |                          |
| DATE    | STEP | Description of NC<br>Section A | Initial<br>Chief Eng | Corrective Action Section Action Description Chief Eng | on B<br>Sign<br>Date |         |            | Approval<br>Chief Eng         | Approval<br>QC Inspector |
|         |      |                                | Office Ling          | Cillel Erig  | Date                 |         |            |                               |                          |
|         |      |                                |                      |  |                      |         |            |                               |                          |
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|         |      |                                |                      |  |                      |         |            |                               |                          |
|         |      | W. J.                          |                      |  |                      |         |            |                               |                          |
|         |      |                                |                      |  |                      |         |            |                               |                          |

#### **Picklist Print** Page 4 May-29-12 2:57:14 PM Work Order ID: 84931 \*84931\* Parent Item: D209-669-043 \*D209-669-043\* Parent Item Name: Replacement Skidtube Start Date: 29/05/2012 **Required Date:** 16/07/2012 Start Qty: 1.00 Required Qty: 1.00 D2594-1 Manufactured 230 Each 311.0000 14 \*\* Plug, 205 Skidtube Location Loc Qty Loc Code FP001 98 73401 30 74442 18 79495 50 FP-A 213 73401 0 78590, 213 D3564-9 Manufactured No 230 Each 22.0000 \*\* Wearshoe Location Loc Qty Loc Code FG 76950 FP001 18 67590 69943 82255 13 D3564-11 Manufactured 230 Each 8.0000 \*\* Wearshoe

May-29-12 2:57:14 PM

Shop Packet Print

Loc Oty

Loc Code

Location

77056

80341

FG

FP001

Page 4

| W/O:    |         |                   | W                           | ORK ORDER CHANG              | ES           |         |        |                               | •                        |
|---------|---------|-------------------|-----------------------------|------------------------------|--------------|---------|--------|-------------------------------|--------------------------|
| DATE    | STEP    | PRO               | CEDURE CH                   | ANGE                         | Ву           | Date    | Qty    | Approval Chief Eng / Prod Mgr | Approval<br>QC Inspector |
|         |         |                   |                             |                              |              | =       |        | T TOO Migi                    |                          |
|         |         |                   |                             |                              |              |         |        |                               |                          |
|         |         |                   |                             |                              | ŀ            |         |        |                               |                          |
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|         | <u></u> |                   |                             |                              |              |         |        |                               |                          |
| Part No | :       | PAR #:            | Fault Ca                    | tegory:                      | _ NCR: Yes   | No DQ   | A:     | Date: _                       |                          |
|         | R       | esolution:        | Disposit                    | ion:                         | _ QA: N/C C  | losed:  |        | Date: _                       |                          |
| NCR:    |         | V                 | VORK OR                     | DER NON-CONFORMA             | ANCE (NC     | R)      |        |                               |                          |
| DATE    | STEP    | Description of NC |                             | Corrective Action Section    |              | Verific | cation | Approval                      | Approval                 |
| DAIE    | SIEP    | Section A         | <b>Initial</b><br>Chief Eng | Action Description Chief Eng | Sign<br>Date | & Secti | ion C  | Chief Eng                     | QC Inspector             |
|         |         |                   |                             |                              |              |         |        |                               |                          |
|         |         |                   |                             |                              |              |         |        |                               |                          |
|         |         |                   |                             |                              |              |         |        | :                             |                          |
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|         | ļ       |                   |                             |                              |              |         |        |                               |                          |
|         |         |                   |                             |                              |              |         |        |                               |                          |
|         |         |                   |                             |                              |              | :       |        |                               |                          |
|         |         |                   |                             |                              |              | ļ       |        |                               |                          |

#### **Picklist Print** Page 5 May-29-12 2:57:14 PM Work Order ID: 84931 \*84931\* Parent Item: D209-669-043 \*D209-669-043\* Parent Item Name: Replacement Skidtube Start Date: 29/05/2012 **Required Date:** 16/07/2012 Start Qty: 1.00 Required Qty: 1.00 D3564-5 Manufactured No 230 13.0000 Each \*\* Wearshoe Location Loc Qty Loc Code FG 2 34806 2 FP001 11 77609 3 82254 8 D3566-1 Manufactured No 230 Each 31.0000 \*D3566-1\* \*\* Location Loc Qty Loc Code FP -22 81619 10 FP002 53 68924 2 80919 3 83898 16 D3566-5 Manufactured 230 Each 21.0000 \*\* Gasket

| W/O:    |      |  | W                    | ORK ORDER CHANG              | ES             |              | -                             |                          |
|---------|------|--|----------------------|------------------------------|----------------|--------------|-------------------------------|--------------------------|
| DATE    | STEP | PRO  | CEDURE CH            | ANGE                         | Ву             | Date Qty     | Approval Chief Eng / Prod Mgr | Approval<br>QC Inspector |
|         |      |  |                      |                              |                |              |                               |                          |
|         |      |  |                      |                              |                |              |                               |                          |
|         |      |  |                      |                              |                |              |                               |                          |
|         |      |  |                      |                              |                |              |                               |                          |
|         |      |  |                      |                              |                |              |                               |                          |
| Part No | :    | PAR #:   | Fault Cat            | legory:                      | _ NCR: Yes 1   | No DQA:      | Date: _                       |                          |
|         | Re   | solution:  | Dispositi            | on:                          | _ QA: N/C Clo  | sed:         | Date: _                       |                          |
| NCR:    |      | \  | WORK ORI             | DER NON-CONFORMA             | ANCE (NCR)     |              |                               |                          |
| DATE    | STEP | Description of NC  |                      | Corrective Action Section    |                | Verification | Approval                      | Approval                 |
| DAIL    | SILF | Section A  | Initial<br>Chief Eng | Action Description Chief Eng | Sign &<br>Date | Section C    | Chief Eng                     | QC Inspector             |
| -       |      |  |                      |                              |                |              |                               |                          |
|         | :    |  |                      |                              |                |              |                               |                          |
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|  |                             |                  |                  |                  |         | ~        |          |           |                   |                         |                             | SKIDTUBE ASSEMBLY  EXTRUSION CROSS BOLT SPACER PLUG O-RING AFT CAP WEB WEB WEARSHOE (REPLACES D2577-1) | 3<br>ES D2677-1)                                   | SKIDTUBE ASSEMBLY EXTRUSION CROSS BOLT SPACER O-RING AFT CAP WEB WEB WEARSHOE (REPLACES D2577-1) WEARSHOE (REPLACES D2577-3) | S D2577-1)   | S D2577-1)  | S D2577-1)   | \$<br>\$\text{S}\text{D2577-1}\$<br>\$\text{S}\text{D2577-3}\$<br>\$\text{S}\text{D2577-5}\$  | S D2577-1)<br>ES D2577-1)<br>ES D2577-3)  | S D2577-1) ES D2577-1) ES D2577-3)  | S D2577-1)   | ES D2577-1)  | ES D2577-1)  |
| <u>}</u>                                       |                             | ۲                |                  |                  |         | ËR       | KR.      | Ä         | SER.              | <b>第</b>                | <b>光</b>                    | JER CES D2577  | SER<br>NCES D2577<br>NCES D2577                    | EXTRUSION CROSS BOLT SPACER PLUG O-RING AFT CAP WEB WEARSHOE (REPLACES D2577-1) WEARSHOE (REPLACES D2577-3)                  | ZER<br>VCES D2577<br>VCES D2577<br>VCES D2577                            | ZER<br>VCES D2577<br>VCES D2577<br>VCES D2577                           | ZER<br>VCES D2577<br>VCES D2577<br>VCES D2577  | ZER<br>(CES D2577<br>(CES D2577<br>(CES D2577   | XCES D2577<br>CES D2577<br>CES D2577  | ZER<br>(CES D2577<br>(CES D2577<br>(CES D2577   | ZER<br>VCES D2577<br>VCES D2577<br>VCES D2577  | XER<br>CES D2577<br>CES D2577<br>CES D2577   | XER<br>CES D2577<br>CES D2577<br>CES D2577   |
| MBLY<br>MBLY                                   | MB! Y                       |                  |                  |                  |         | SPACER   | PACER    | PACER     | ACER              | ACER                    | ACER                        | ACER<br>PLACES D   | ACER<br>PLACES DI<br>PLACES DI                     | PLACES DI<br>PLACES DI<br>PLACES DI  | PLACES DI<br>PLACES DI<br>PLACES DI                                      | PLACES DI<br>PLACES DI<br>PLACES DI                                     | PLACES DO  | PLACES DI<br>PLACES DI<br>PLACES DI   | PLACES DY<br>PLACES DY<br>PLACES DY   | PLACES DY<br>PLACES DY<br>PLACES DY   | PLACES DO PLACES | PLACES DY PLACES | PLACES DY<br>PLACES DY<br>PLACES DY  |
| SKIDTUBE ASSEMBLY<br>SKIDTUBE ASSEMBLY         | ASSEMBL                     |                  |                  | ı                |         | JLT SPAC | JLT SPAC | NLT SPACI | )LT SPACI         | NLT SPACI               | )LT SPACI                   | NLT SPACI  | NLT SPACI  | NLT SPACI  | E (REPLA)  | E (REPLA)   | E (REPLA)  | E (REPLA)   | NLT SPACI   | E (REPLA)   | E (REPLA)  | E (REPLA)  | E (REPLA)  |
| TUBE AS  | TUBE AS                     | 140              |                  | ADVION<br>ADVION | SS BOLT |          | G        | NG<br>NG  | S<br>NG<br>CAP    | S CAP                   | S NG                        | S CAP CAP RSHOE (I   | SANG<br>CAP<br>RSHOE (I                            | SANOE (I   | PLUG O-RING AFT CAP WEB WEB WEARSHOE (I                                  | SOUNG<br>CAP<br>RSHOE (I<br>RSHOE (I<br>RSHOE (I<br>RSHOE (I            | RSHOE (I RSH | S<br>NG<br>CAP<br>RSHOE (I<br>RSHOE (I<br>RSHOE (KET<br>KET                                   | RSHOE (I RSHOE (I RSHOE (I RSHOE (I RET KET   | SOLUTION OF THE PROPERTY OF TH  | SOLUTION OF THE PROPERTY OF TH | SAP<br>NG<br>CAP<br>CAP<br>RSHOE (I<br>RSHOE (ET<br>KET<br>KET<br>KET  | SAP<br>NG<br>CAP<br>CAP<br>RSHOE (I<br>RSHOE (ET<br>RET<br>KET<br>KET<br>KET<br>KET<br>KET<br>KET<br>KET   |
| SKIDTUBE A<br>SKIDTUBE A<br>EXTRUSION          | SKIDT(<br>EXTRU             | EXTRU            | EXTRU            |                  | CROSS   | SULT     |          | O-RING    | O-RING<br>AFT CAP | O-RING<br>AFT CA<br>WEB | O-RING<br>WEB<br>WEB        | O-RING<br>AFT CA<br>WEB<br>WEB<br>WEB  | O-RING<br>AFT CA<br>WEB<br>WEB<br>WEARS            | O-RING<br>WEB<br>WEB<br>WEARS<br>WEARS   | O-RING<br>WEB<br>WEARS<br>WEARS<br>WEARS                                 | O-RING AFT CAR WEB WEB WEARSI WEARSI WEARSI WEARSI WEARSI               | O-RING AFT CAF WEB WEB WEARSI WEARSI WEARSI WEARSI GASKET GASKET   | O-RING WEB WEB WEARSI WEARSI WEARSI WEARSI GASKET GASKET                                      | O-RING WEB WEB WEB WEARR WEARR WEARR GASKE GASKE                                      | O-RING<br>WEB<br>WEB<br>WEARS<br>WEARS<br>WEARS<br>GASKE<br>GASKE<br>GASKE  | O-RING<br>WEB<br>WEB<br>WEARS<br>WEARS<br>GASKE<br>GASKE<br>BOLT   | O-RING<br>WEB<br>WEBRARS<br>WEARS<br>WEARS<br>GASKE<br>GASKE<br>BOLT<br>BOLT   | O-RING AFT CAP WEB WEB WEARSH WEARSH WEARSH WEARSH GASKET GASKET GASKET GASKET BOLT INSERT WASHER  |
|  |                             | Ť                |                  | 1                | )       | 1        |          |           |                   |                         |                             |  |  |  |  |   |  |   |   |   |  |  |  |
| -041<br>-043<br>1-190                          | 1-190                       | 1-190            | 1-190            | 9                | 8       | 4-1      | ,        | 5-4       | 4-3<br>55         | 6-1<br>6-1              | 6-3                         | 6-1<br>6-3<br>4-9  | 6-1<br>6-3<br>1-11                                 | 6-1<br>6-3<br>6-3<br>1-11<br>4-5   | 6-1<br>6-1<br>6-3<br>6-3<br>7-11<br>7-11<br>7-15                         | 6-1<br>6-1<br>6-3<br>6-3<br>1-11<br>1-15<br>6-1                         | 6-1<br>6-1<br>6-3<br>7-11<br>7-11<br>6-1<br>6-1  | 6-1<br>6-1<br>6-3<br>6-3<br>1-11<br>1-15<br>6-1<br>6-5  | 6-1<br>6-1<br>6-1<br>1-11<br>1-11<br>6-1<br>6-5<br>7-15                               | 66-1<br>66-1<br>66-1<br>66-1<br>6-1<br>6-1<br>6-1<br>7-15<br>7-13<br>032-130<br>032-130   | 86-1<br>66-1<br>66-1<br>7-11<br>7-15<br>8-13<br>8-13<br>8-13<br>8-13<br>8-13<br>8-13<br>8-13<br>8-13   | 44-3<br>66-1<br>66-1<br>72-130<br>032-130<br>032-130<br>54A<br>5A  | 44-3<br>66-1<br>66-1<br>74-1<br>66-1<br>6-5<br>5-15<br>5-15<br>5-15<br>5-15<br>5-15<br>5-1   |
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|  |                             |                  |                  |                  |         |          |          |           |                   |                         |                             |  |  |  |  |   |  |   |   | ALS Or AK   | ALS OT AKS   | ALS OT AKS   | ALS<br>Or AKK<br>Or AKK  |
| × -  | × -                         | 1                | j                |                  | 6       | 14       | 14       | 6         | 7                 |                         | 1                           | 1 1  | 7  | 7 1-1-1-   | 7 1-1-1-1  | 2 2   | v + 0  | v   | v   | 4 + 2 - 4   | 1 2- 4 4   | 1 2 - 4 4 4 4  | 7  |
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GENERAL NOTES:

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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SUBJECT TO AMENDMENT WITHOUT NOTICE

WORK ORDER 8493/ 12/05/2 4

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1 LENGTH OF D2500-1 EXTRUSION BEFORE BENDING = 190 INCHES.

3) INSERT D2926-1/-3 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241/291

ADHESIVE PER DART QSI 015 BEFORE BENDING. ENSURE HOLES LINE-UP.

4) BEND AS A SMOOTH RADIUS STARTING WITH A MAXIMUM CENTERLINE RADIUS OF 60 AND ENDING WITH A MINIMUM RADIUS OF 30. A MAXIMUM REDUCTION OF 0.200 IN DIAMETER IS ALLOWABLE IN THE BENT PORTION OF THE TUBE.

5) BEND AS A SMOOTH RADIUS STARTING WITH A MAXIMUM REDUCTION OF 0.200 IN DIAMETER IS ALLOWABLE IN THE BENT PORTION OF THE TUBE.

6) USE DART DRILL Z0.297 HOLES FOR WEARSHOE INSERTS. INSTALL ALS7-1032-130 PER SECTION C-C AFTER FINISH. INSTALL AN3CAA BOLTS AND AN9EOC10L WASHERS WITH SIKAFLEX-241/291. 6

F 80

FINISH

ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2926-1/-3 WEB. POWDER COAT ASSEMBLY WHITE (REF 4.3.5.1) PER DART QSI 005 4.3 BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4 INSERT D2594-1 PLUG CWV D2594.3 O-RING IN HOLES MARKED IP (BOTH SIDES OF TUBE) AFTER FINISH (12 PLACES).

10) ALL DIMENSIONS ARE IN INCHES

| NTS          | <b>MBLY</b> | AH-1 (209) SKIDTUBE ASSEMBLY  | 7      | 0                   | نہ           | DE APPR.   |
|--------------|-------------|---|--------|---------------------|--------------|------------|
| SCALE        |             | TITLE   | 0      | 1                   | Œ)           | APPROVED   |
| SHEET 1 OF 3 | o,          | D2906   | 1      | a                   | PR.          | MFG. APPR. |
| REV. B       |             | DRAWING NO.   | 4.     | B                   | Ð            | CHECKED    |
| i e          | O, CANA     | HAWKESBURY, ONTARIO, CANADA   | 8      | J                   |              | DRAWN      |
| TD           | ACF         | DART AEROSPACE I TD   |        | b                   |              | DESIGN     |
| DATE         | Β¥          | DESCRIPTION   | Ω      |                     |              | REV.       |
| 04.06.22     | မ           |   |        | SUE                 | NEW ISSUE    | ٧          |
|              |             | PG 3 C3: CORRECTED -043 CAP P/N;<br>PG 3 D7: 38 PLACES WAS 44 PLACES; | RECTE! | 3: COR!<br>7: 38 PL | PG3C<br>PG3D |            |
|              |             | PG 2 C7: REMOVE AFT Ø0.640 HOLE FROM -041;                            | OVE AF | 7: REM              | PG 2 C       |            |
| 07.08.21     | 8           |   | TE 10; | PG 1: ADD NOTE 10;  | PG 1: A      | മ          |
|              |             | CHANGE WEARPLATE HARDWARE TO SS;                                      | RPLAT  | E WEA               | CHANG        |            |
|              |             | ADD STAINLESS STEEL WEARPLATES AND GASKETS                            | SS STE | <b>TAINLE</b>       | ADD S.       |            |
|              |             | UPDATE DRAWING FORMAT; RE-ORGANIZE;                                   | VING F | E DRAV              | UPDAT        |            |

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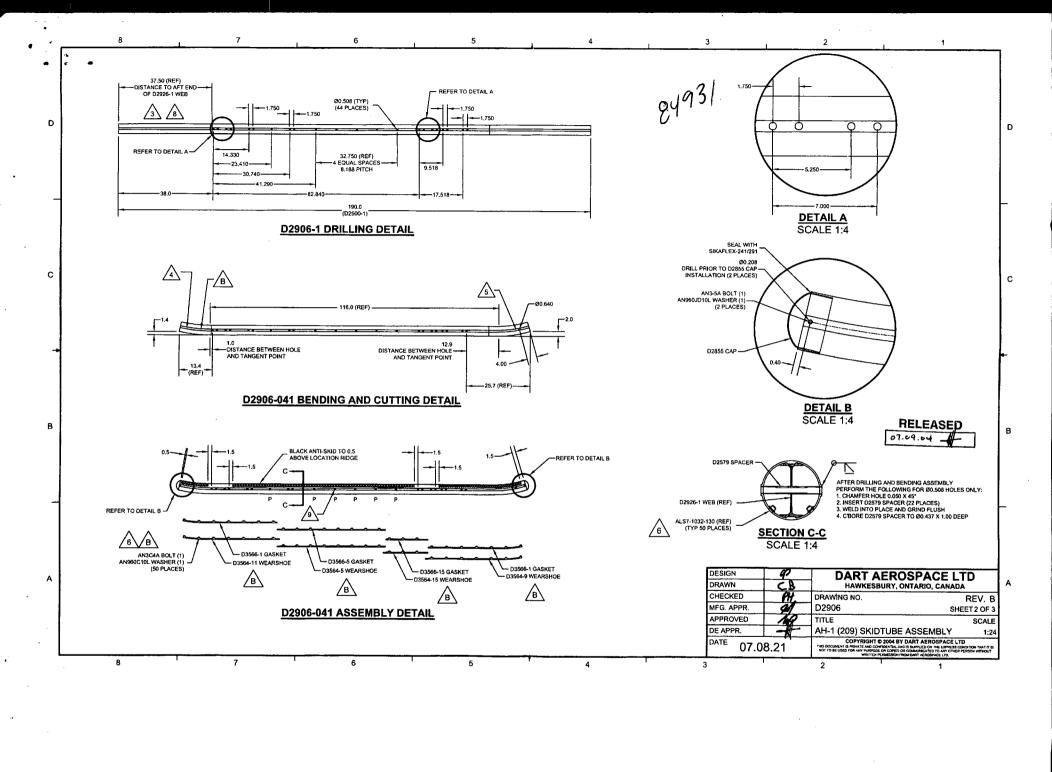
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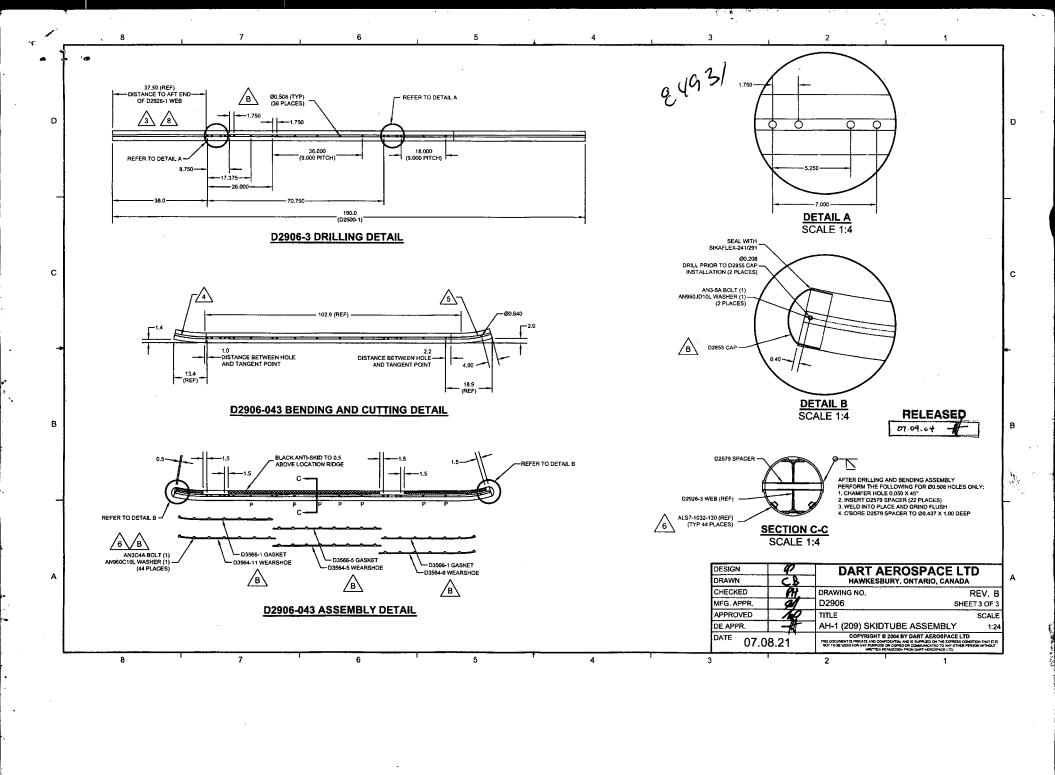
|  | Dart | <b>Aeros</b> | pace | Ltd |
|--|------|--------------|------|-----|
|--|------|--------------|------|-----|

| W/O:    |      |                   | W                    | ORK ORDER CHANG              | ES          |       |         |                               |                          |
|---------|------|-------------------|----------------------|------------------------------|-------------|-------|---------|-------------------------------|--------------------------|
| DATE    | STEP | PRO               | CEDURE CH            | ANGE                         | Ву          | Date  | Qty     | Approval Chief Eng / Prod Mgr | Approval<br>QC Inspector |
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| Part No | :    | PAR #:            | Fault Cat            | tegory:                      | _ NCR: Yes  | No DO | 2A:     | Date: _                       |                          |
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| NCR:    |      | V                 | WORK ORI             | DER NON-CONFORM              | ANCE (NC    | R)    |         |                               |                          |
| DATE    | STEP | Description of NC |                      |                              | tion B      | Verif | ication | Approval                      | Approval                 |
| DAIL    | JILI | Section A         | Initial<br>Chief Eng | Action Description Chief Eng | Sign<br>Dat |       | ction C | Chief Eng                     | QC Inspector             |
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| Part No | :    | PAR #:            | Fault Cate           | egory:                                | _ NCR: Yes 1   | No DQA:      | Date: _                       |                          |
|         | R    | esolution:        | Dispositio           | n:                                    | _ QA: N/C Clo  | sed:         | Date: _                       |                          |
| NCR:    |      |                   | WORK ORD             | ER NON-CONFORMA                       | NCE (NCR)      |              |                               |                          |
| DATE    | STEP | Description of NC |                      | Corrective Action Section             |                | Verification | Approval                      | Approval                 |
| DAIL    | JILL | Section A         | Initial<br>Chief Eng | Action Description Chief Eng          | Sign &<br>Date | Section C    | Chief Eng                     | QC Inspector             |
|         |      | 'A'               |                      |                                       |                |              |                               |                          |
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| W/O:        |        |                  | W. Carlotte                           | W          | ORK OR     | DER CHANGE                       | ES           |         | •      | -                             |                          |
| DATE        | STEP   |                  | PRO                                   | OCEDURE CH | ANGE       |                                  | Ву           | Date    | Qty    | Approval Chief Eng / Prod Mgr | Approval<br>QC Inspector |
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| Part No     | :      |                  | PAR #:                                | Fault Ca   | tegory:    |                                  | NCR: Yes     | No DQ   | A:     | Date: _                       |                          |
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| NCR:        |        |                  | •                                     | WORK OR    | DER NON    | -CONFORMA                        | NCE (NC      | R)      |        |                               |                          |
| DATE        | STEP   | Des              | cription of NC                        | Initial    | Corrective | e Action Section  on Description | on B<br>Sign |         | cation | Approval                      | Approval                 |
|             |        | * *              | Section A                             | Chief Eng  | ACII       | Chief Eng                        | Dat          |         | tion C | Chief Eng                     | QC Inspector             |
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